

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013631**Date Inspected:** 27-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

8AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at CA048 bike path side of segment. Welder is identified as Mr. Du Hengyou (037743). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at CA052 bike path side of segment. Welder is identified as Mr. Li Jian (067829). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

7CW+7DW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at CA041 counter weight side of segment. Welder is identified as Mr. Cao Xinglong (069683). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U4b-FCM-1.

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Shield Metal Arc Welding (SMAW) welding was performed on weld joint 020 located at DP649-001 cross beam side of segment. Welder is identified as Mr. Xu Changxue (066002). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-3213-B-U3b.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 020~030 located at BP649-001 bottom plate of segment. Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-B-U2a-1.

8CE+8BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBE8C cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Submerge Arc Welding (SAW) welding was performed on weld joint 003 located at OBE8A deck plate of segment. Welder is identified as Mr. Gu Caihong (053748). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

Submerge Arc Welding (SAW) welding was performed on weld joint 003 located at OBE8A deck plate of segment. Welder is identified as Mr. Mu Jingfen (054458). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

7CE+7DE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at OBE7A cross beam side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR1426 repair procedure.

Y Location of repairs areas by above noted welder (054467) is located at 570mm.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle Testing (MT) Technician performed MT on various locations in the trial assembly yard. Locations and indications are as followed:

8BE+8CE

1. Root passes on weld joint OBE8A-003 located on the deck plate prior to SAW welding.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
